

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000114**Date Inspected:** 03-Apr-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Zhou Daging	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No N/A	
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No N/A	
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No N/A	
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No N/A	
		Delayed / Cancelled:	Yes No N/A	
Bridge No:	34-0006	Component:	Welder Qualifications	

Summary of Items Observed:

The CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the welder and welding operator qualification tests scheduled for this project. Third Party Moody International, Zhou Daging and assistances were observed by the QA inspector performing verifications of the welding parameters, amperages, voltages, travel speeds, preheat and interpass temperatures for the welder qualification tests as follows:

Shielded Metal Arc Welding: ZPMC, welders, Du Heng Hua, Zhang Mingwu, Tang Yonqing, Wang Hui, Li Zai Jun, Zhang Chun Feng, Xu Xiao Bing, Zhou Zheng Wei, Feng Hua Jun, Zhou Zhong Hong and Li Jin Quan were observed by the QA Inspector performing welder qualification test plates 2007-0403-050, 051, 052, 053, 054, 055, 056, 057, 058, 059 and 060 respectively, using the shielded metal arc welding (SMAW) process in the vertical (3G) position with the 4.0 mm diameter TL-508 electrode following the welding procedure specification WPS-B-T-2213-B-U2a-F on the 26 mm thick fracture critical test plate. The root opening of the joint was approximately 6 mm. The QA Inspector performed random verifications amperages, voltages, travel speeds, preheat and heat interpass temperatures after Moody International verifications. The QA inspector recorded that the welding appeared to be in compliance with contract documents.

Submerged Arc Welding: ZPMC, welding operator Lui Juan was observed by the QA Inspector performing welder qualification test plates 2007-0403-002 using the automated submerged arc welding (SAW) process single electrode in the flat (1G) position with the 4.8 mm diameter JW-3 electrode following the welding procedure specification WPS-B-T-2221-B-U2-S on the 26 mm thick fracture critical test plate. The root opening of the joint was approximately 16 mm. The QA Inspector performed random verifications amperages, voltages, travel speeds, preheat and interpass temperatures after Moody International verifications. The QA inspector recorded that the welding parameters appeared to be in compliance with contract documents.

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Summary of Conversations:

The QA inspector did not have any significant conversations on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Acuna,Alfredo	Quality Assurance Inspector
Reviewed By:	McClary,David	QA Reviewer
